

Work Order ID 57111

March 23, 2010 7:43:56 AM

# PRELIMINARY ISSUE



Page 1

Item ID: D4083-1

Accept



Setup

Start



Revision ID:

Item Name: Bracket

Stop



Start Date: 3/23/10 Start Qty: 3.00



Cust Item ID:

Required Date: 3/30/10 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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100   
0.00

MAT NOT pulled

Waterjet   
FLOW WATER JET  
0.00

BB 10-3-23

FLOW CNC Waterjet  
304.050   
Memo: 1-Cut as per Dwg D4083  
Dwg Rev: PA1 10-03-23  
Prog Rev: L1M  
2-Deburr if necessary

EP 10/03/24

110   
0.00

QC   
QC2- Inspect parts off machine FAI/FAIB  
0.00

BB 10-3-23

Quality Control

120   
QC   
QC8- Inspect parts - second check  
0.00

Quality Control

8x9 1003/24 to Polen Day only  
Memo: 0.00

QC APPROVAL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D4083-1

Accept



Setup Start



Revision ID:

Item Name: Bracket

Stop



Start Date: 3/23/10 Start Qty: 3.00



Cust Item ID:

Required Date: 3/30/10 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



Brake NC

Brake NC

Bend as per dwg  
NC BRAKE

0.00

Memo D4083 PA2

0.00

40,03-30

Sb ad 4/06

(2)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

S100407 (2) in PA2 palm Day

0.00

QC APPROVAL

S100416 vs  
to "New A" Day  
Rebox

150



Identify as per dwg &amp; Stock Location:

0.00

Memo

0.00

3 ship less 1C  
over ERIC D.

Pre/4/16 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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March 23, 2010 7:43:57 AM

Item ID: D4083-1

Accept



Setup Start



Revision ID:

Item Name: Bracket

Stop



Start Date: 3/23/10 Start Qty: 3.00



Cust Item ID:

Required Date: 3/30/10 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

160



QC

Quality Control

Operation  
Description

QC21- Final Inspection - Work Order Release

Set Up/  
Run Hours

0.00

Draw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

10/04/10 JJ

Memo

0.00

u 10-04-16

POSITIVE RECALL

EFFECTIVE 10-03-23 AUTH u

RELEASED 10-04-16 DATE ls

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

March 23, 2010 7:43:55 AM

Page 1

Work Order ID: 57111



Parent Item: D4083-1



Parent Item Name: Bracket

Start Date: 3/23/10

Required Date: 3/30/10

Comments: IPP Rev:A new issue DD 10.03.11 verified by:EC

Start Qty: 3.00

Required Qty: 3.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S18GA		Purchased		No		100	sf	225.4922	0.1737	6		

304/316 .050 Sheet



10-3-23

## Warehouse

### Location

#### Main Warehouse

MAT	225.4921632
108156	0.98526316
111743	23.7174
112885	72.7895
113062	128

102178

## Loc Qty

## Loc Code

(9)

102178

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

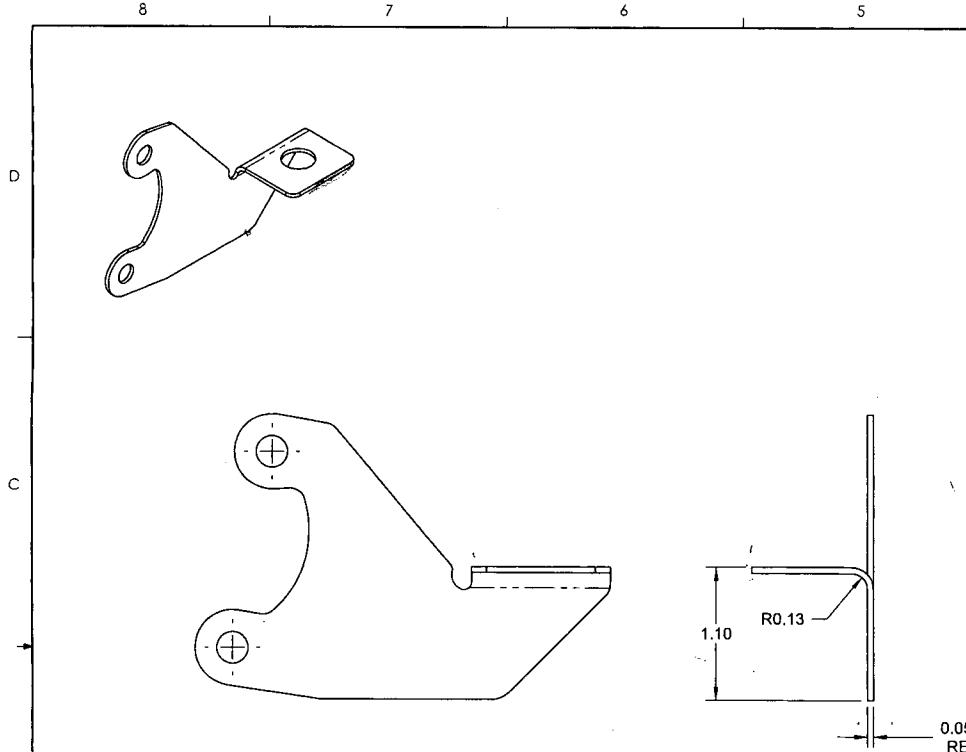
DART AEROSPACE LTD	Work Order:	57111
Description: BRACKET	Part Number:	D4083-1
Inspection Dwg: D4083-1 Rev: PA1		Page 1 of 1

## **FIRST ARTICLE INSPECTION CHECKLIST**

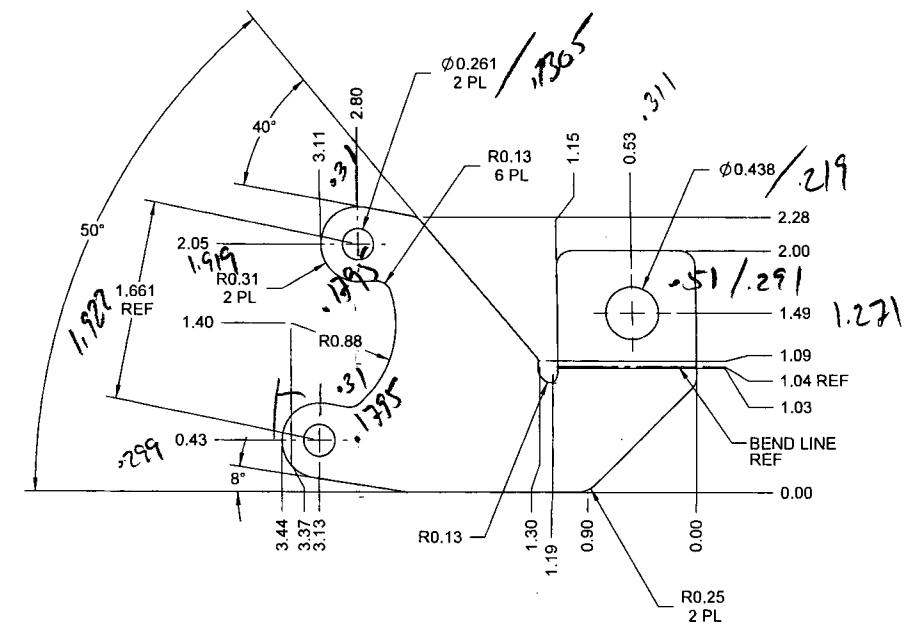
## X First Article      Prototype

Measured by:	VB	Audited by:	S	Prototype Approval:	N/A
Date:	10-3-23	Date:	10/03/23	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



**D4083-1 BRACKET**  
(MAKE FROM D4083-1F FLAT PATTERN)



**D4083-1F FLAT PATTERN**

#### NOTES:

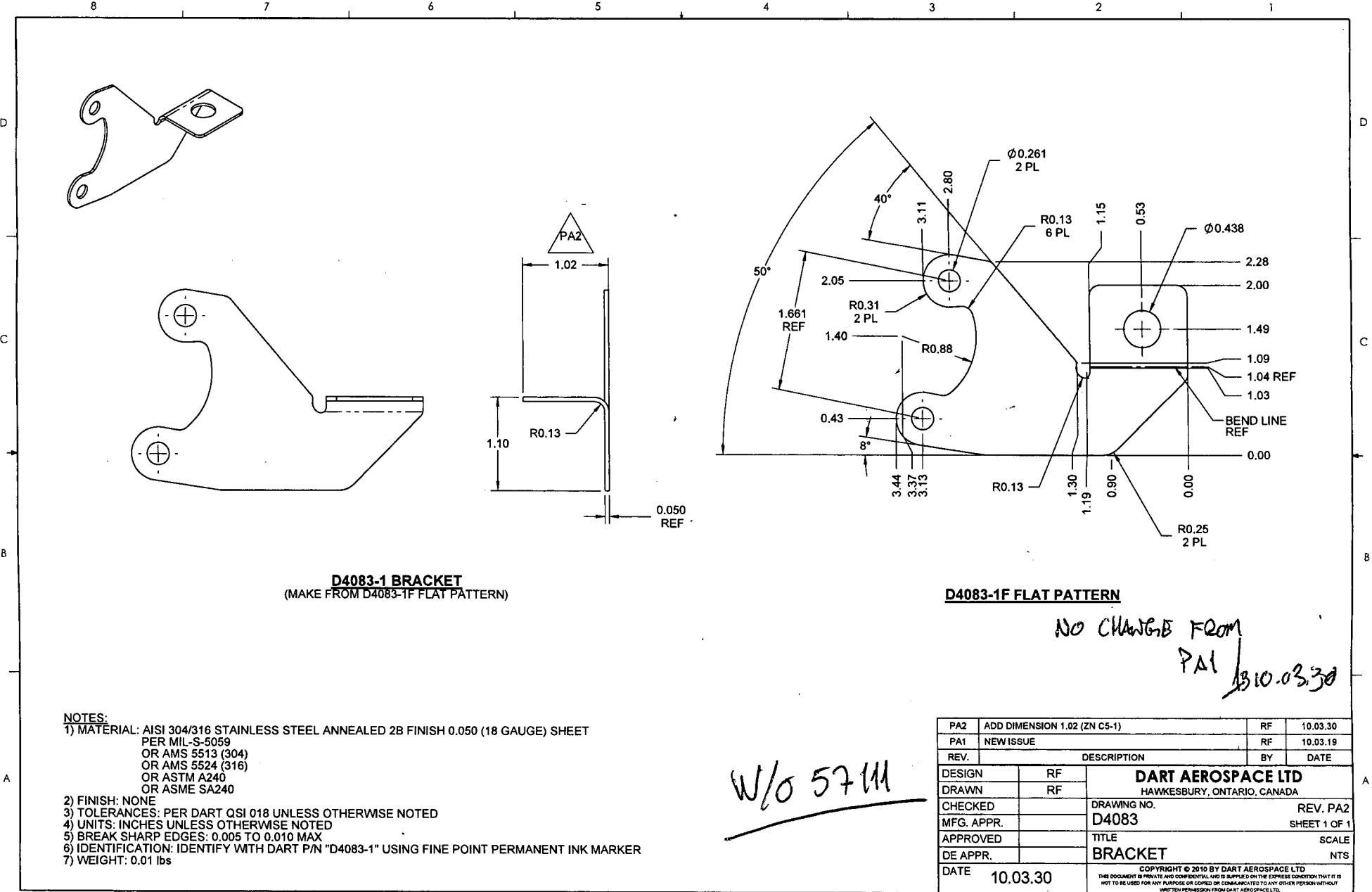
**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ANNEALED 2B FINISH 0.050 (18 GAUGE) SHEET  
PER MIL-S-5059  
OR AMS 5513 (304)  
OR AMS 5524 (316)  
OR ASTM A240  
OR ASME SA240
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4083-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.01 lbs

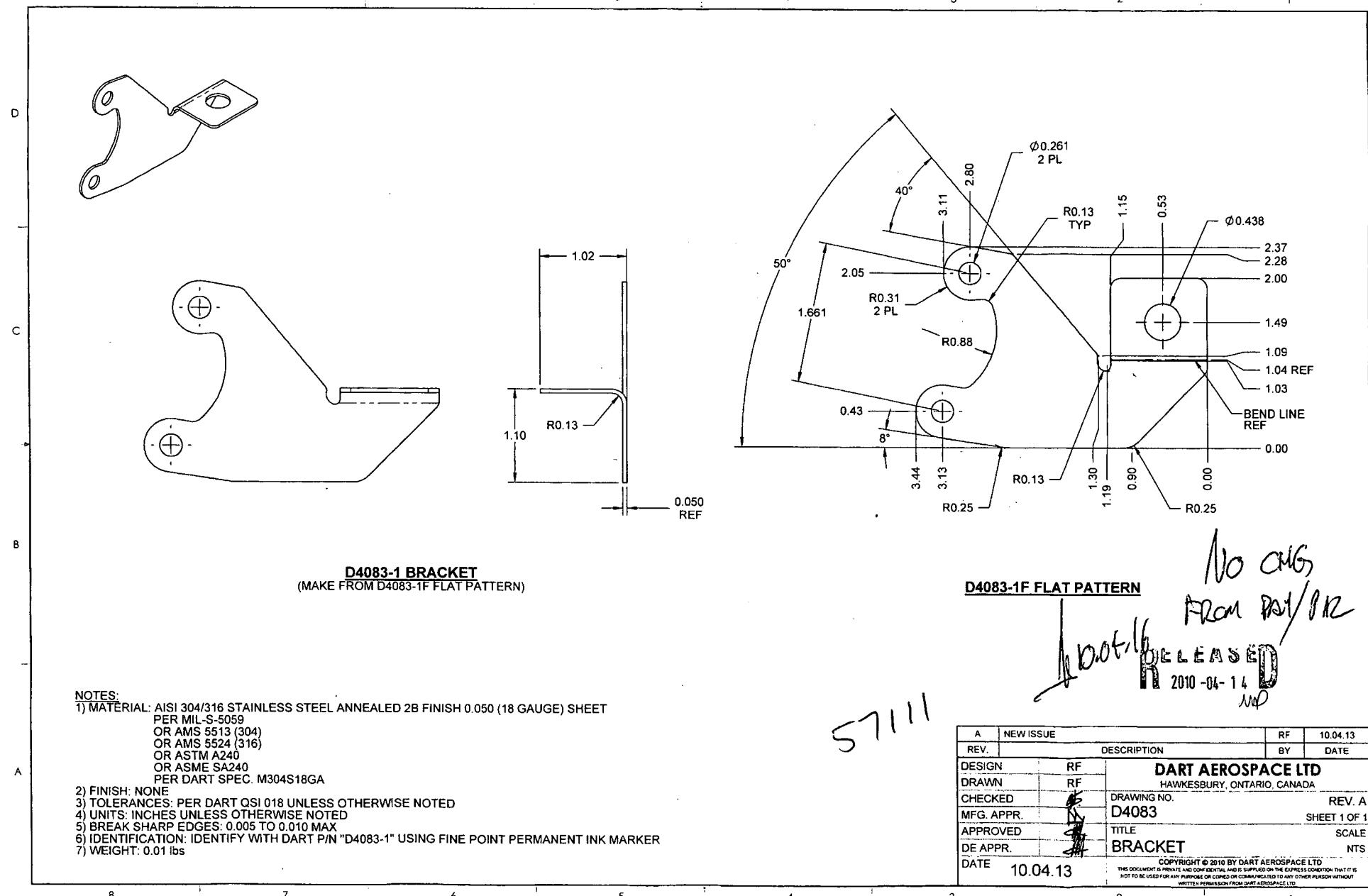
WU 5711

PA1	NEW ISSUE	RF	10.03.19
REV.	DESCRIPTION		BY DATE
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. P.A.
MFG. APPR.		D4083	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
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8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1